

Date: Thursday, 19/03/2009 11:05:55 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FLOOR PROCTOR RH
<b>Job Number</b> : 46585	
<b>Estimate Number</b> : 11225	
<b>P.O. Number</b> :	<b>Part Number</b> : D32803
<b>This Issue</b> : 19/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3280 REV.D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 45706	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 02/04/2009 <b>Qty:</b> 5 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JULIE DAWSON</u>	
<b>Comment</b> :	

Est Rev:A 04.07.01 New issue KJ/JLM  
 Est RevB 07.09.12 Thermoform in house DL  
 Est Rev C 08.03.11 Dwg. Rev Change. DL  
 Est Rev D 08.04.15 Material Change DL

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

MLEXS093F600602

GE PLASTICS LEXAN SHEET



**Comment:** Qty.: 4.3330 sf(s)/Unit Total : 21.6650 sf(s)  
 GE PLASTICS LEXAN SHEET

Material Batch Number N 110877

DL 09/03/19

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING

**Comment:** HAND FINISHING THERMOFORMING

DL 09/03/19

1) Cut Blanks

3.0

THERMOFORMING

THERMOFORMING MACHINE

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 012

Dwg. Rev. 0Folio Rev. B

DL 09/03/19

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

DL 09/03/19

DL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 19/03/2009 11:05:55 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR RH

Job Number: 46585

Part Number: D32803

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



(X5)

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

Wf. 08/03/23

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(X5)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

Wf. 09/03/23

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Wf. 09/03/23 (X5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Wf. 09/03/23 (5)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Wf. 09/03/24

Job Completion



Wf. 09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46585
<b>Description:</b> R22 Floor Protector, RH		<b>Part Number:</b> D3280-3
<b>Inspection Dwg:</b> D3280	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

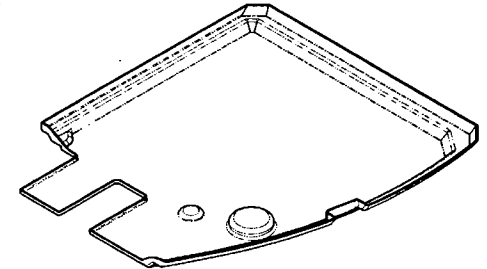
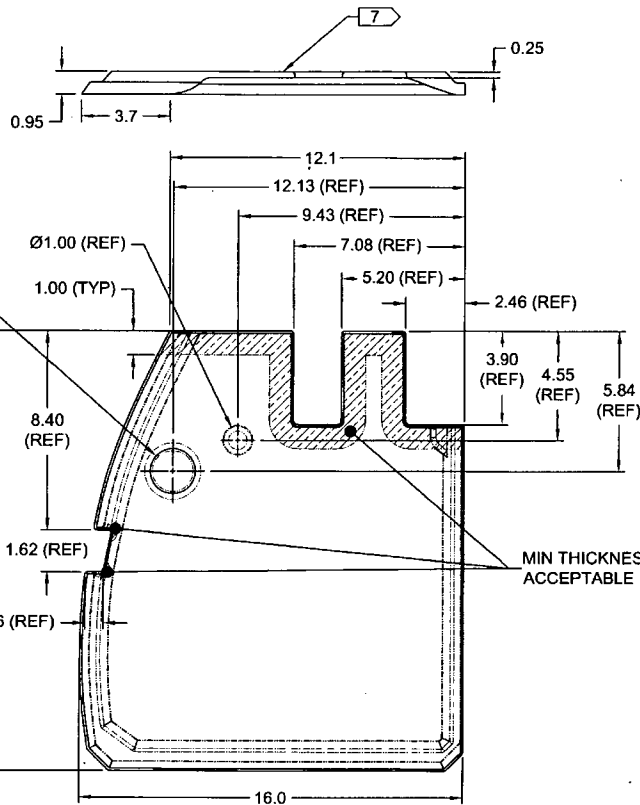
<b>Measured by:</b> <i>DL</i>	<b>Date:</b> 09/03/19
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#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.3	✓			
15.8	+/-0.100	15.8	✓			
12.1	+/-0.100	12.0	✓			
0.95	+/-0.030	0.94	✓			
0.25	+/-0.030	0.255	✓			
0.070	Min	0.74	✓			
0.050	Min	0.62	✓			

<b>Measured by:</b> <i>DL</i>	<b>Date:</b> 09/03/23
<b>Audited by:</b> <i>[Signature]</i>	<b>Date:</b> 9/3/23
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

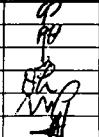
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL <i>[Signature]</i>	<i>DL</i>



**D3280-1 FLOOR PROTECTOR**

**D3280-1 NOTES:**

- 1) THERMOFORM WITH MOLD D3280-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3280-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.94 lb

D	THICKNESS 0.093 WAS 0.125, MIN. THICKNESS 0.070 WAS 0.080, P/N & B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2); CORRECT WEIGHTS (ZN A8-1, A8-2); HOLE SIZE Ø1.88 WAS Ø0.211 (ZN C7-1)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.12
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.03.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
		DRAWING NO.	REV. D
		D3280	SHEET 1 OF 2
		TITLE	SCALE
		FLOOR PROTECTOR	NTS

SHOP COPY  
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